

Work Order ID 53224

October 27, 2009 12:41:41 PM



Page 1

Item ID:	D2563	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Step Weldment Assembly					
Start Date:	27/10/2009	Start Qty:	6.00	Cust Item ID:		
Required Date:	10/11/2009	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	<i>PH</i>	Date:	<i>09-10-27</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2563	Rev C								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2244 to 89.70" at 34 deg as per dwg D2563		<i>PH</i>	<i>09.10.28</i>			<i>6</i>	<i>0</i>	
	2-Deburr ends		<i>PH</i>						
	3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343		<i>PH</i>						
	A/R AL ROD Batch: <i>M111311</i>								
	4- Grind		<i>PH</i>	<i>M111494</i>					
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control							<i>PH</i>	<i>09.10.29</i>	

Work Order ID 53224

October 27, 2009 12:41:41 PM



Page 2

Item ID: D2563

Accept



Setup Start



Revision ID: C

Stop



Item Name: Step Weldment Assembly

Start Date: 27/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

2) 807/10/29

(46)

φ



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

12 09.10.29

6

φ



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

12 09-10-29

(6)



QC

Memo

0.00

Quality Control

Work Order ID 53224

October 27, 2009 12:41:41 PM



Page 4

Item ID: D2563

Accept



Setup Start



Revision ID: C

Stop



Item Name: Step Weldment Assembly

Start Date: 27/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

Touch up Alodine then
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11/21/08

START TIME:

7:45AM

OVEN TEMPERATURE:

320°C

FINISH TIME:

8:15AM

0.00

MO 09/11/02
EL 09/11/03

X6

Ø

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Hand Finishing

Memo

Wing walk

0.00

BR 09-11-2
MO 09/11/04

⑥

P70

200

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

BR 09-11-4

⑥

W/O: 53224

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-11-04	190	permanent change	MA	09/11/04		EL 09-11-04	S 02/11/04

Part No: D2563 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53224

October 27, 2009 12:41:41 PM



Page 5

Item ID: D2563

Accept



Setup Start



Revision ID: C

Stop



Item Name: Step Weldment Assembly

Start Date: 27/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP
53223

0.00

Packaging

9/11/4 (60) SP

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/04 [Signature]
RD 09-11-4

Picklist Print

October 27, 2009 12:41:46 PM

Page 1

Work Order ID: 53224

Parent Item: D2563RevC

Parent Item Name: Step Weldment Assembly


Comments:

Start Date: 27/10/2009

Required Date: 10/11/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2244-116RevD1		Manufactured	No			100	Each	49.0000	6.0000			
												
Step Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

49

38023

49

D2561RevB

Manufactured No

100

Each

16.0000

12.0000



Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

47177

16

D2564RevB1

Manufactured No

100

Each

55.0000

12.0000



Mounting Angle

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

55

45243

2

47966

53

12 09.10.28

12 09.10.28

12 09.10.28

2
10

Picklist Print

Page 2

October 27, 2009 12:41:46 PM

Work Order ID: 53224



Parent Item: D2563RevC



Parent Item Name: Step Weldment Assembly



Start Date: 27/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2673-34RevB		Manufactured	No			100	Each	22.0000	12.0000			
											<i>2009.10.28</i>	
End Plate												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

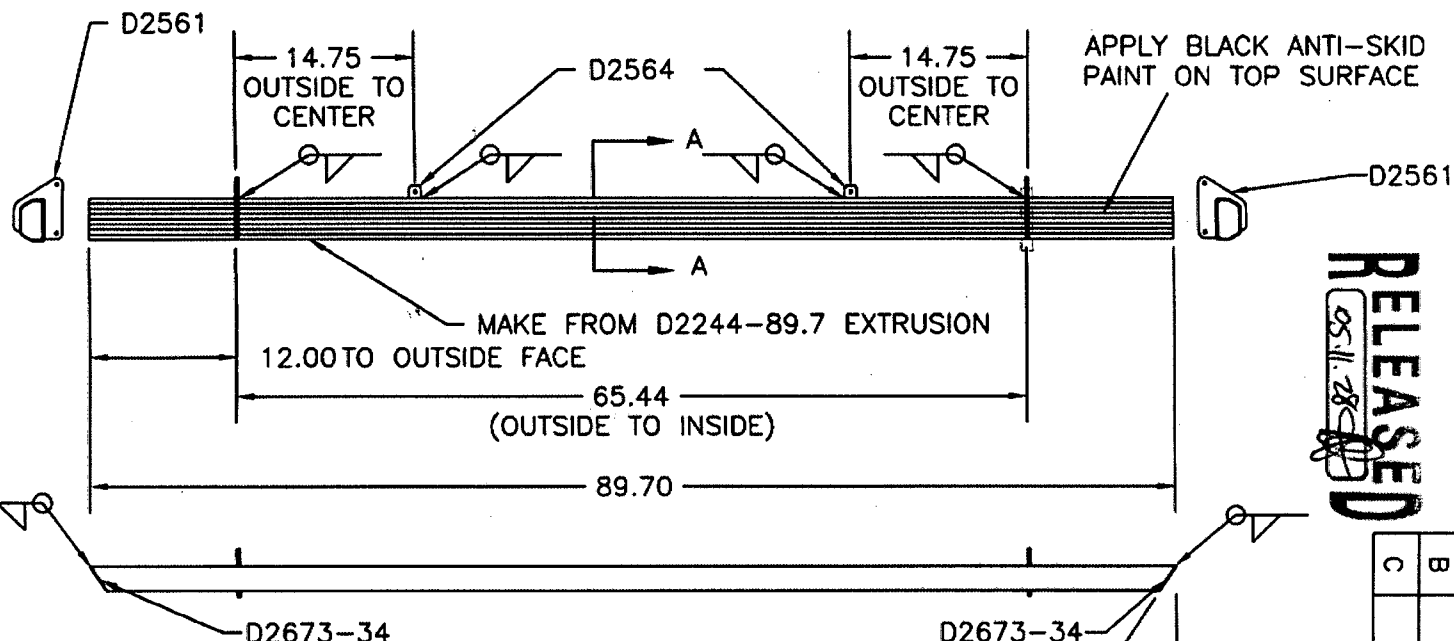
36406

22

606

DART

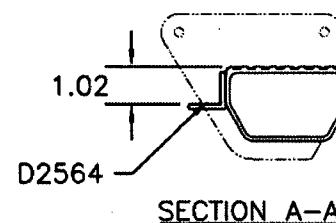
RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOWN
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK IN PROGRESS
NO. 53224

0510-27

DESIGN	BW	DRAWN BY	PT	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. C
				D2563	SHEET 1 OF 1
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY	SCALE	1:15
A	96.04.26	NEW ISSUE			
B	97.05.14	END CAPS CHANGED (WAS D2248)			
C	05.11.14	UPDATE NOTES			